

Date: Thursday, 15/01/2009 11:15:15 AM  
 User: Julie Dawson

## Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PANEL-350 AFT CANOPY  
 Job Number : 44820  
 Estimate Number : 13098  
 P.O. Number :  
 This Issue : 15/01/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : D36561  
 First Issue : / / Type : THERMOFORMING Drawing Number : D3656 REV B  
 Previous Run : 42208 Drawing Revision : B  
 Material :  
 Due Date : 05/02/2009 Qty: 4 Um: Each  
 Written By :  
 Checked & Approved By : BB 09/01/23  
 Comment : Est. Rev. A 07/12/13 New issue DL verified by:DD  
 Est. Rev. B 08/09/25 Dwg. Update DL.

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET
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Comment: Qty.: 32.0000 sf(s)/Unit Total : 128.0000 sf(s)  
 GE PLASTICS LEXAN SHEET  
 batch: M105494

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks to fit frame size

BB 09/01/23

X4

3.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3656-1 and Folio FTA 015 using tool DT 8986

Dwg. Rev. B  
 Folio Rev. A

BB 09/01/23

X4

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/01/23

X4

P70

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3656-1 PAR #: WA Fault Category: THESE FORM NCR: Yes No DQA: 1A Date: 09-01-29  
 Resolution: See AP Disposition: See AP QA: N/C Closed: PD Date: 09/02/02

NCR: <u>214820</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/01/26</u>	<u>30</u>	<u>2 parts did not form properly.</u> <u>LC machining malfunction</u>	<u>AB</u> <u>09/01/26</u>	<u>Scrap 2 parts, adjust machine settings and update fabio.</u>	<u>09/01/26</u> <u>DN</u>	<u>S</u> <u>09/01/26</u>	<u>AB</u> <u>09/01/26</u>	<u>S</u> <u>09/01/26</u>

NOTE: Date &amp; initial all entries



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-350 AFT CANOPY

Job Number: 44820

Part Number: D36561

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S 09/01/26

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions as per dwg D3656

DB 09/01/26 (X1)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

DB 09/01/26 (X1)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/26 @

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PP44641

DS 09/01/27 (X1)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/28 JF

Job Completion



W 09/01/27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 44820
Description: Panel		Part Number: D3656-1
Inspection Dwg: D3656	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Free of visual flaws (bumps, cracks, voids, etc.)	✓			

Measured by: BB Date: 09/01/26

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.7	+/-0.030	.72	✓			
0.070	Min	.83	✓			
0.050	Min	.065	✓			

Measured by: BB Date: 09/01/26  
Audited by: S Date: 09/01/26  
Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DL	AF



